

Date: Friday, 7/4/2008 12:48:42 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
 Job Number : 40281
 Estimate Number : 10833
 P.O. Number :
 This Issue : 7/4/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/12 Type : MACHINED PARTS
 Previous Run : 39888
 Part Number : D29331
 Drawing Number : D2933 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 7/30/2008 Qty: 10 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC
 Est Rev: C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: B34822

J.F. 08/08/25

(10)

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

J.F. PML 08/08/26 (10)

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.F. PML 08/08/26 (10)

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. PML 08/08/26 (10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 40281

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DIP 08/08/27

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

[Signature]

09/09/27

(x10)

7.0

POWDER COATING

POWDER COATING



M108523



(10X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*2:30
3:20
3:00*

M-F 08/08/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



[Signature]



Comment: INSPECT POWDER COAT

08-08-27

(x10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

428A

AS 08/08/27

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(K)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/29

Job Completion



MF 08-08-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | |
|--|-----------------------------|
| DART AEROSPACE LTD | Work Order: 40281 |
| Description: 206 Saddle, Inboard, Left side | Part Number: D2933-1 |
| Inspection Dwg: D2933 Rev: C DSK: Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|-----|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| A | 0.100 | 0.140 | | .119 | .121 | .123 | .123 | .120 |
| B | 0.100 | 0.140 | | .119 | .121 | .121 | .121 | .121 |
| C | 0.100 | 0.140 | | .100 | .132 | .134 | .136 | .135 |
| D | 0.210 | 0.230 | | .225 | .221 | .219 | .219 | .221 |
| E | 1.245 | 1.255 | | 1.251 | 1.250 | 1.250 | 1.249 | 1.250 |
| F | 1.245 | 1.255 | | 1.249 | 1.250 | 1.250 | 1.249 | 1.250 |
| G | 2.495 | 2.505 | | 2.503 | 2.500 | 2.500 | 2.500 | 2.500 |
| H | 0.510 | 0.515 | | .510 | .510 | .510 | .510 | .511 |
| I | 1.572 | 1.582 | | 1.578 | 1.578 | 1.577 | 1.577 | 1.575 |
| J | 2.495 | 2.505 | | 2.502 | 2.502 | 2.499 | 2.499 | 2.499 |
| K | 0.257 | 0.262 | | Ø.258 | Ø.258 | .260 | .259 | .259 |
| L | 0.312 | 0.317 | | Ø.313 | .314 | .314 | .314 | .314 |
| M | 0.235 | 0.240 | | .235 | .235 | .235 | .236 | .237 |
| N | 0.100 | 0.140 | | .119 | .121 | .121 | .121 | .122 |
| O | 0.540 | 0.560 | | .548 | .550 | .549 | .547 | .545 |
| P | 0.490 | 0.510 | | .501 | .500 | .500 | .501 | .500 |
| Q | 3.715 | 3.725 | | 3.723 | 3.723 | 3.718 | 3.719 | 3.719 |
| R | 2.470 | 2.510 | | 2.495 | 2.495 | 2.490 | 2.492 | 2.492 |
| S | 0.240 | 0.270 | | .256 | .250 | .250 | .250 | .250 |
| T | 0.100 | 0.180 | | .140 | .140 | .140 | .140 | .140 |
| U | 1.625 | 1.635 | | 1.630 | 1.630 | 1.629 | 1.629 | 1.631 |
| V | 1.362 | 1.372 | | 1.369 | 1.369 | 1.368 | 1.367 | 1.366 |
| W | 0.316 | 0.321 | | Ø.320 | Ø.320 | .321 | .320 | .320 |
| X | 1.125 | 1.145 | 1 | 1.132 | 1.138 | 1.134 | 1.134 | 1.135 |
| Y | 1.565 | 1.585 | | 1.572 | 1.578 | 1.368 | 1.368 | 1.369 |
| Z | 0.178 | 0.198 | | Ø.188 | Ø.188 | .188 | .188 | .188 |
| AA | | | | | | | | |
| AB | | | | | | | | |
| AC | | | | | | | | |
| AD | | | | | | | | |
| AE | | | | | | | | |

Accept/Reject

| | |
|---------------------------------------|-----------------------|
| Measured by: J.F. / <i>aml</i> | Date: 08/08/26 |
| Audited by: DSP 08/08/27 | Date: 08/08/27 |
| Prototype Approval: N/A | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF | |
| C | 06.10.03 | Removed DT8683, DT8686 & DT8690 | KJ/JLM | |
| D | 07.03.21 | Revised per drawing revision C | KJ/JLM | |
| E | 08.01.16 | DT8695 A/B removed from dimension Y | KJ/EC/DD | |

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 40281 |
| Description: 206 Saddle, Inboard, Left side | | Part Number: | D2933-1 |
| Inspection Dwg: D2933 Rev: C DSK: Rev: | | Page 1 of 1 | |

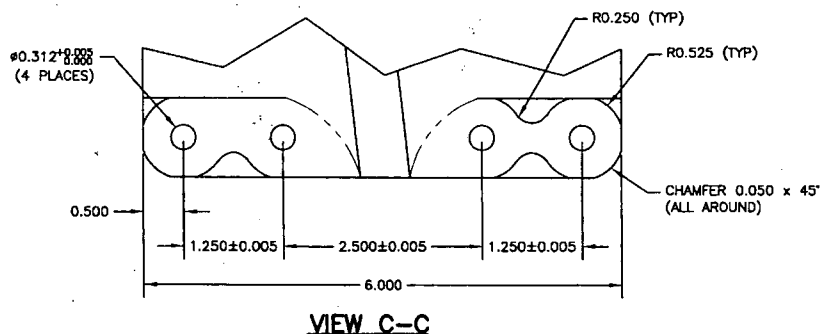
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| A | 0.100 | 0.140 | | .119 | .120 | .120 | .121 | .126 |
| B | 0.100 | 0.140 | | .119 | .120 | .120 | .121 | .126 |
| C | 0.100 | 0.140 | | .135 | .135 | .135 | .136 | .136 |
| D | 0.210 | 0.230 | | .218 | .222 | .221 | .221 | .221 |
| E | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| F | 1.245 | 1.255 | | 1.250 | 1.250 | 1.250 | 1.250 | 1.250 |
| G | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | 2.500 |
| H | 0.510 | 0.515 | | .511 | .510 | .511 | .511 | .510 |
| I | 1.572 | 1.582 | | 1.578 | 1.577 | 1.577 | 1.578 | 1.578 |
| J | 2.495 | 2.505 | | 2.499 | 2.500 | 2.500 | 2.499 | 2.499 |
| K | 0.257 | 0.262 | | .259 | .259 | .259 | .259 | .259 |
| L | 0.312 | 0.317 | | .314 | .314 | .314 | .314 | .314 |
| M | 0.235 | 0.240 | | .238 | .237 | .237 | .238 | .238 |
| N | 0.100 | 0.140 | | .120 | .122 | .121 | .122 | .122 |
| O | 0.540 | 0.560 | | .545 | .545 | .546 | .546 | .546 |
| P | 0.490 | 0.510 | | .501 | .501 | .500 | .499 | .501 |
| Q | 3.715 | 3.725 | | 3.717 | 3.717 | 3.719 | 3.716 | 3.717 |
| R | 2.470 | 2.510 | | 2.496 | 2.493 | 2.495 | 2.496 | 2.496 |
| S | 0.240 | 0.270 | | .250 | .250 | .251 | .251 | .250 |
| T | 0.100 | 0.180 | | .140 | .140 | .140 | .140 | .140 |
| U | 1.625 | 1.635 | | 1.627 | 1.631 | 1.630 | 1.627 | 1.627 |
| V | 1.362 | 1.372 | | 1.367 | 1.368 | 1.366 | 1.368 | 1.368 |
| W | 0.316 | 0.321 | | .320 | .326 | .320 | .326 | .320 |
| X | 1.125 | 1.145 | | 1.133 | 1.137 | 1.136 | 1.135 | 1.135 |
| Y | 1.565 | 1.585 | | 1.569 | 1.570 | 1.569 | 1.570 | 1.569 |
| Z | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | .188 |
| AA | | | | | | | | |
| AB | | | | | | | | |
| AC | | | | | | | | |
| AD | | | | | | | | |
| AE | | | | | | | | |
| Accept/Reject | | | | | | | | |

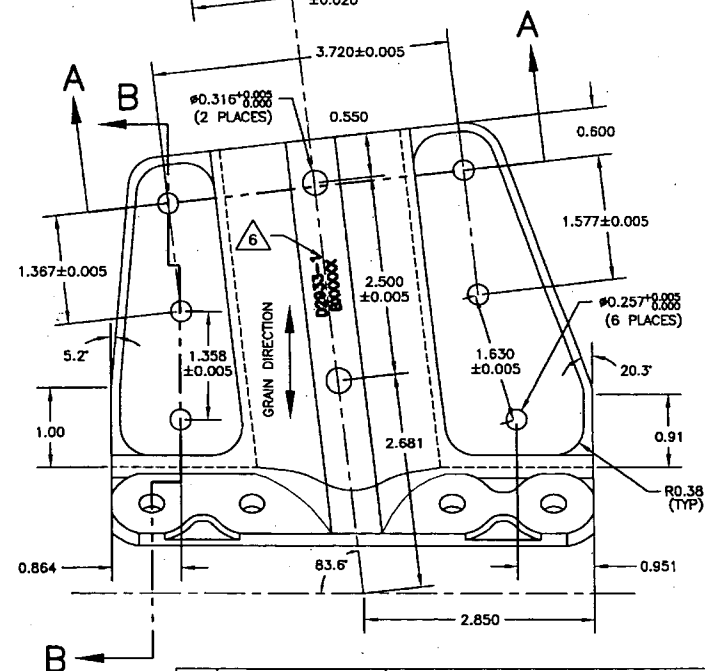
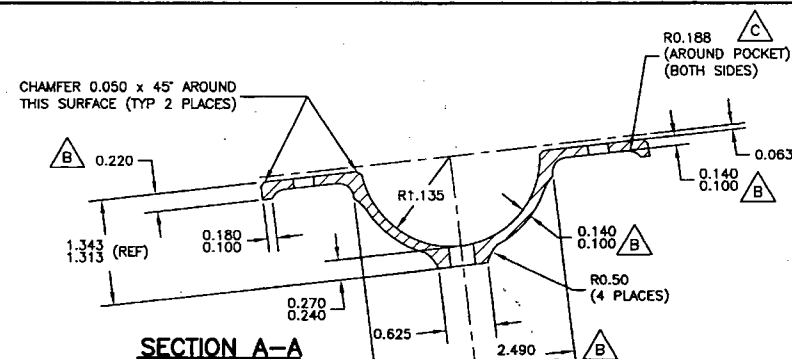
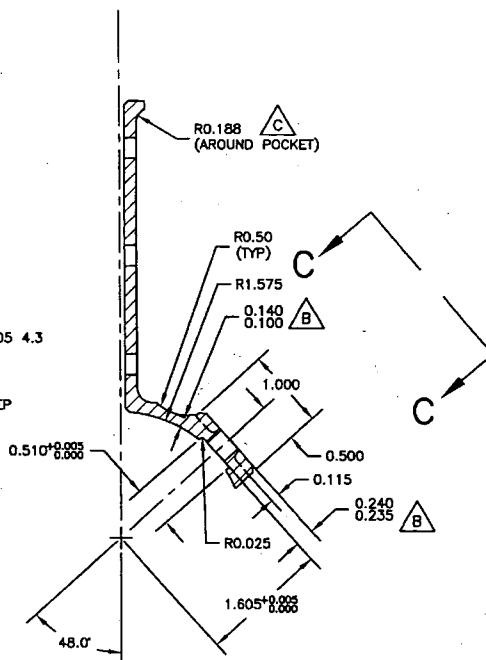
| | |
|--------------------------------|-----------------------|
| Measured by: <i>Am</i> | Date: 08/08/26 |
| Audited by: <i>DAP</i> | Date: 08/08/27 |
| Prototype Approval: N/A | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | | New Issue | RF | |
| B | 02.12.12 | Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B | KJ/RF | |
| C | 06.10.03 | Removed DT8683, DT8686 & DT8690 | KJ/JLM | |
| D | 07.03.21 | Revised per drawing revision C | KJ/JLM | |
| E | 08.01.16 | DT8695 A/B removed from dimension Y | KJ/EC/DD | |



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



| | | |
|-------------------|----------|-------------------------------|
| C | 06.11.09 | R0.188 WAS R0.30 TO R0.25 |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.10.29 | NEW ISSUE |
| DESIGN | 4 | DRAWN BY CB |
| CHECKED | PH | APPROVED |
| DATE | 06.11.09 | TITLE SADDLE INSIDE |
| DRAWING NO. D2933 | | REV. C SHEET 1 OF 1 |
| SCALE | | 2:3 |

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